

Work Order ID 55678

January 27, 2010 11:25:25 AM

Page 1

Item ID: D412-702-123B

Accept

Revision ID:

Item Name: Harness Assembly

Start Date: 1/27/10 Start Qty: 1.00

Required Date: 2/05/10 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: *PL*Date: *1-27* Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

DSI 9469

A

50

0.00



DC

Document Control

Memo

Photocopy bluefile & type labels per PPP D412-702-123B / DSI 9469
CHG001

0.00

100

Pick Kit

0.00



Packaging

Packaging

Memo

0.00

110

0.00



Small Fab

Small Fab

Memo

Assemble as per DSI9469

0.00

*N/A**EP 10/02/10**EP 10/02/10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55678

January 27, 2010 11:25:25 AM



Page 2

Item ID: D412-702-123B

Accept



Setup Start



Revision ID:

Stop



Item Name: Harness Assembly

Start Date: 1/27/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/05/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

5/10/2/10



QC

Memo

0.00

Quality Control

10

130

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-702-123B / DS1 9469

Location: _____

PPP rev: _____

2H

10-2-10 SP (12)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/11

MF

10-2-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 27, 2010 11:25:28 AM

Page 1
3

Work Order ID: 55678



Parent Item: D412-702-123B

Parent Item Name: Harness Assembly

Start Date: 1/27/10

Required Date: 2/05/10

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3570-4 Manufactured No



Bracket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST245A

19

52886

19

D3579-048 Manufactured No



Shoulder Harness

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3

55119

3

MS24694-S50 Purchased No



Screw

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

218

108936

6

111020

18

113538

194

EP 10/02/10

EP 10/02/10

EP 10/02/10

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D412-702-123B



Parent Item Name: Harness Assembly

Start Date: 1/27/10

Required Date: 2/05/10

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10L 		Purchased	No				Each	4,049.000	4.0000			
Washer												



Ep 10/02/10

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

4049

101291

16

105793

49

110985

3984

4

MS21042L3

Purchased

No

Each

2,943.000 1.0000



Ep 10/02/10

Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2943

110844

35

111274

27

111668

52

112314

331

112385

498

113523

300

113537

700

113644

1000

4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D412-702-123B



Parent Item Name: Harness Assembly

Start Date: 1/27/10

Required Date: 2/05/10

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3569-3 Decal		Manufactured	No				Each	17.0000	1.0000			

Warehouse

Location

Main Warehouse

ST245

55395

Loc Qty

N
A
mf 10-2-1

17

17

Loc Code

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

**TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-702 REV. E AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-702 REV. 3**

REF TCCA STC: SH04-7
REF FAA STC: SR01997NY
REF EASA STC: EASA.IM.R.S.00710

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 50876

PURPOSE:

Update the D412-702-041A/045A/-041B/-045B kits for compatibility with the Dart D412-769-011 Aft Facing Seat Kit.

CHANGE:

Quantity (1) each of D412-702-111A/-113A is replaced with D412-702-121A/-123A. Also Qty (4) x AN4-27A bolts are added to the kits for compatibility with the Dart seat. When installing the AN4 bolts in the Dart seat, open the Ø0.188" holes to Ø0.257" (see sheet 4 detail J of this service instruction for reference). Alternate nuts added (see flag note 2 & 3, sheet 4). The parts list in section 25.28 (pg. 87) of ICA-D412-702 Rev. 3 and section 7.0 (pg. 38) of IIN-D412-702 Rev. E is amended as follows:

QTY -041A	QTY -043A	QTY -045A	QTY -047A	QTY -049A	PART NUMBER	DESCRIPTION
X					D412-702-041A	Dart 13-Man 3-Point Shoulder Harness Kit
		X			D412-702-045A	Dart 4-Man 3-Point Aft Facing Shoulder Harness Kit

IS:

1		1			D412-702-111A	HARNESS ASSEMBLY (EXISTING)
1		1			D412-702-121A	HARNESS ASSEMBLY (NEW)
1*		1*			D3570-3	BRACKET
1*		1*			D3579-043	SHOULDER HARNESS
4*		4*			MS24694S50	SCREW
4*		4*			AN960JD10L	WASHER
1*		1*			MS21042L3	NUT
1*		1*			D3569-1	DECAL
1		1			D412-702-113A	HARNESS ASSEMBLY (EXISTING)
1		1			D412-702-123A	HARNESS ASSEMBLY (NEW)
1*		1*			D3570-4	BRACKET
1*		1*			D3579-044	SHOULDER HARNESS
4*		4*			MS24694S50	SCREW
4*		4*			AN960JD10L	WASHER
1*		1*			MS21042L3	NUT
1*		1*			D3569-2	DECAL
4		4			AN4-27A	BOLT (NEW)

WAS:

2		2			D412-702-111A	HARNESS ASSEMBLY
2		2			D412-702-113A	HARNESS ASSEMBLY

* DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: [Signature]
D. SHEPHERD (DE # 02)

DATE: 09.12.10
CERT. NO.: SH04-7
ISSUE NO.: 3

B	ADD FLAG NOTE 2 & 3 AND OPEN AN3 HOLES TO AN4	CP	09.12.10
A	NEW ISSUE, NCR 09-068	CP	09.06.30
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>90</u>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<u>90</u>		
CHECKED	<u>90</u>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9469	SHEET 1 OF 5
APPROVED	<u>[Signature]</u>	TITLE	SCALE
DE APPR.	<u>[Signature]</u>	AFT-FACING SEAT UPDATE	NTS
DATE	09.12.10	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

The parts list in section 25.28 (pg. 93) of ICA-D412-702 Rev. 3 and section 7.0 (pg. 40) of IIN-D412-702 Rev. E is amended as follows:

QTY -041B	QTY -043B	QTY -045B	QTY -047B	QTY -049B	PART NUMBER	DESCRIPTION
X					D412-702-041B	Dart 13-Man 3-Point Shoulder Harness Kit
		X			D412-702-045B	Dart 4-Man 3-Point Aft Facing Shoulder Harness Kit

IS:

1		1			D412-702-111B	HARNESS ASSEMBLY (EXISTING)
1		1			D412-702-121B	HARNESS ASSEMBLY (NEW)
1*		1*			D3570-3	BRACKET
1*		1*			D3579-047	SHOULDER HARNESS
4*		4*			MS24694S50	SCREW
4*		4*			AN960JD10L	WASHER
1*		1*			MS21042L3	NUT
1*		1*			D3569-3	DECAL
1		1			D412-702-113B	HARNESS ASSEMBLY (EXISTING)
1		1			D412-702-123B	HARNESS ASSEMBLY (NEW)
1*		1*			D3570-4	BRACKET
1*		1*			D3579-048	SHOULDER HARNESS
4*		4*			MS24694S50	SCREW
4*		4*			AN960JD10L	WASHER
1*		1*			MS21042L3	NUT
1*		1*			D3569-3	DECAL
4		4			AN4-27A	BOLT (ADD)

WAS:

2		2			D412-702-111B	HARNESS ASSEMBLY
2		2			D412-702-113B	HARNESS ASSEMBLY

* DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: MSH
D. SHEPHERD (DE # 02)

DATE: 09.12.10
CERT. NO.: SH04-7
ISSUE NO.: 3

DESIGN	<u>90</u>	DART AEROSPACE LTD	
DRAWN	<u>12</u>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>90</u>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9469	SHEET 2 OF 5
APPROVED	<u>SH</u>	TITLE	SCALE
DE APPR.	<u>SH</u>	AFT-FACING SEAT UPDATE	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Figures 4.8 (pg. 25) of IIN-D412-702 Rev. E and 25.12 (pg. 69) of ICA-D412-702 Rev. 3 are updated as follows:

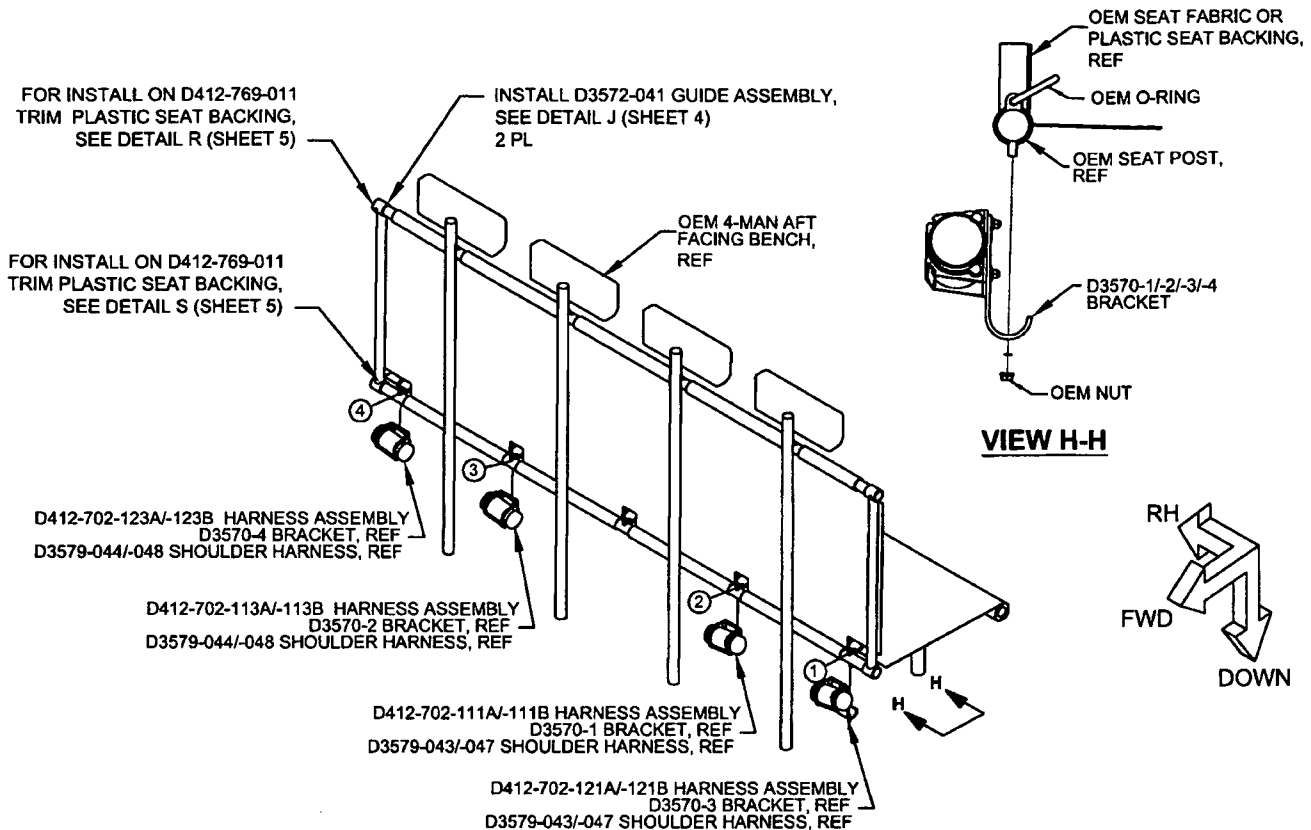


FIGURE 4.8. SHOULDER BELT INSTALLATION
FIGURE 25.12 D412-702-045A/-045B 4-MAN 3-POINT AFT FACING SHOULDER HARNESS KIT

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY: <i>[Signature]</i>	D. SHEPHERD (DE # 02)
DATE: 09.12.10	
CERT. NO.: SH04-7	
ISSUE NO.: 3	

DESIGN	<i>90</i>	DART AEROSPACE LTD	
DRAWN	<i>90</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>90</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9469	SHEET 3 OF 5
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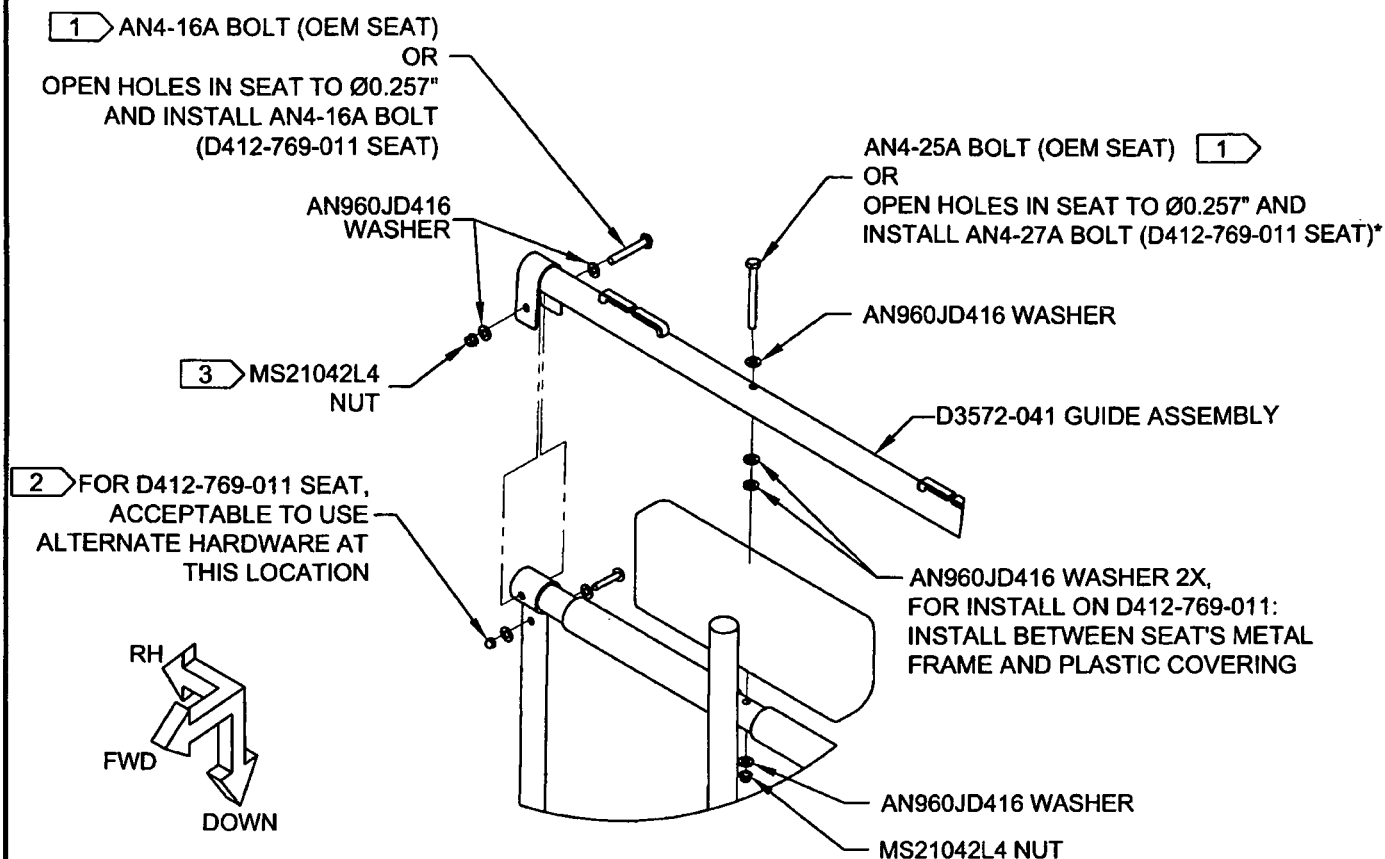
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DETAIL J: D3572-041 INSTALLATION
(RH SHOWN, LH OPPOSITE)

- 1 ACCEPTABLE TO USE LONGER/SHORTER AN4 BOLTS, ADD ADDITIONAL AN960JD416 WASHERS, OR SUBSTITUTE AN960JD416L WASHERS TO ENSURE 1.5-2 THREADS IN SAFETY
- 2 ACCEPTABLE TO USE MS51865-6C AS ALTERNATE NUT. IF ALT NUT IS USED, ADD AN960JD10/10L WASHER AS REQD (HEAD BOLT SIDE) TO ENSURE PROTRUDING THREADS MEASURE 0.160 MIN, 0.190 MAX. (BEFORE NUT INSTALLATION)
- 3 ACCEPTABLE TO USE MS51865-8C AS ALTERNATE NUT. IF ALT NUT IS USED, ADD AN960JD416/416L WASHER AS REQD (HEAD BOLT SIDE) TO ENSURE PROTRUDING THREADS MEASURE 0.200 MIN, 0.250 MAX. (BEFORE NUT INSTALLATION)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 09.12.10
CERT. NO.: SH04-7
ISSUE NO.: 3

DESIGN	<i>qp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>qp</i>		
CHECKED	<i>qp</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9469	SHEET 4 OF 5
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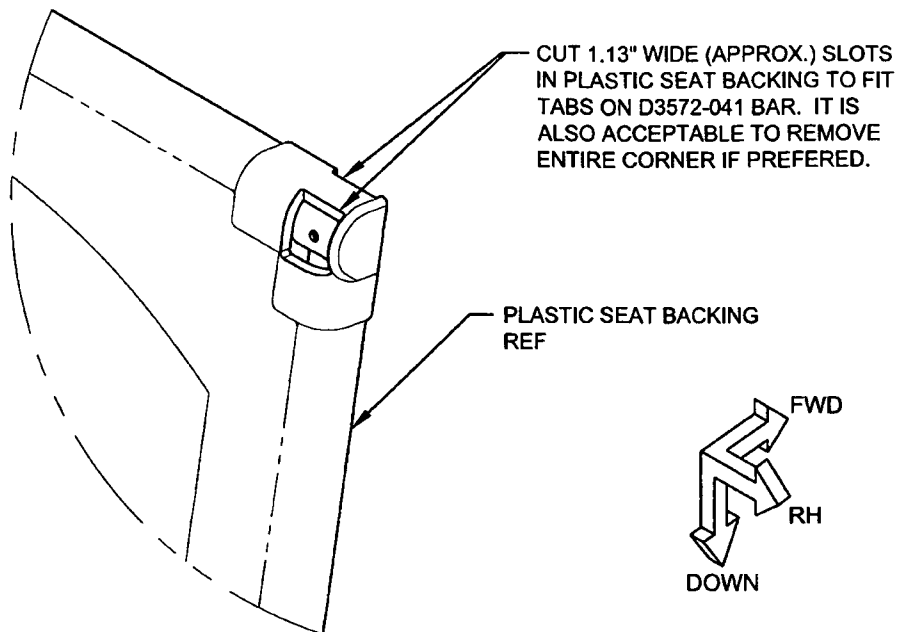
W/O:		WORK ORDER CHANGES					
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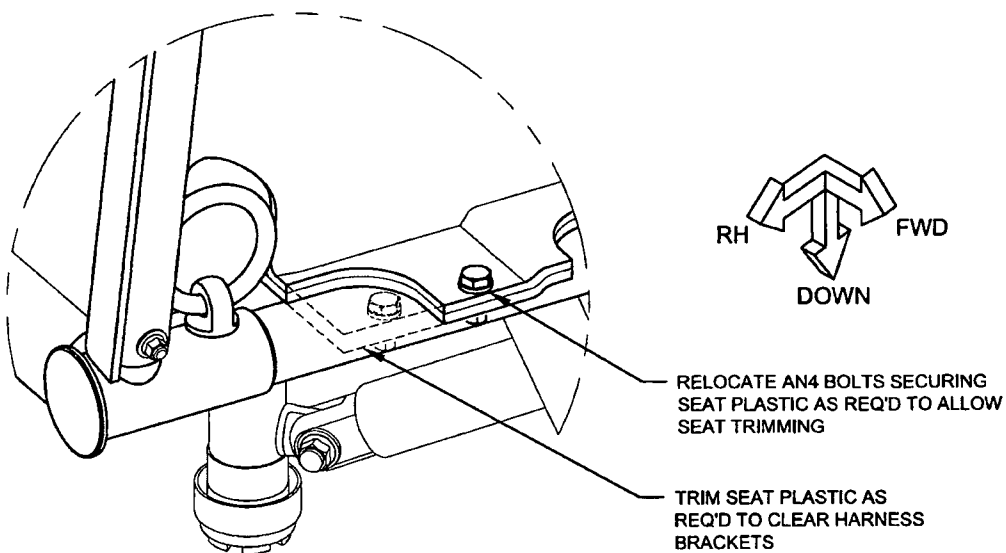
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NOTE: Date & initial all entries



DETAIL R

VIEW LOOKING AT FRONT OF SEAT BACKING, TOP-RH CORNER SHOWN (TOP-LH CORNER SIMILAR),
FOR INSTALL ON D412-769-011 ONLY



DETAIL S

VIEW LOOKING AT REAR OF SEAT, BOTTOM-RH CORNER SHOWN (BOTTOM-LH CORNER SIMILAR),
FOR INSTALL ON D412-769-011 ONLY

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: D. SHEPHERD (DE # 02)

DATE: 09.12.10
CERT. NO.: SH04-7
ISSUE NO.: 3

DESIGN	<u>90</u>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<u>90</u>		
CHECKED	<u>90</u>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9469	SHEET 5 OF 5
APPROVED	<u>90</u>	TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
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